

Date: Wednesday, 21/05/2008 2:20:23 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	39376		
Estimate Number :	12825		
P.O. Number :		Part Number :	D3578041
This Issue :	21/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3578 REVA
First Issue :	//	Project Number :	N/A
Previous Run :	37309	Drawing Revision :	
	Type :	Material :	
	SMALL /MED FAB	Due Date :	23/05/2008
Written By :		Qty:	12
Checked & Approved By :	<i>mf</i>	Um:	Each
Comment :	Est: A 07.04.11 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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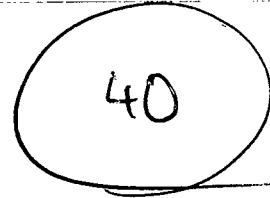


Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.0882 sf(s)
 6061-T6 sheet 0.080"
 (M6061T6S080)
 Batch: 167904 *HB 8-5-22*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3578 (Run prog. D3578-1)
 Dwg Rev: A
 Prog Rev: A *HB 8-5-22*
 2-Deburr if necessary



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE *HB 8-5-22*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/05/26 *40* *HB 8-5-22*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Open rivet holes to 0.098" and C'sink as per dwg D3578

08/05/27 *40*

Date: Wednesday, 21/05/2008 2:20:23 PM
User: Mèlanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39376

Part Number: D3578041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
508/05/27 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

bf 08-05-27

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-27

(40)

9.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nutplate

Batch: *M107279*

CB08/05/27

10.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet

M19099

CB08/05/27

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3578

CB08/05/27 (40)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
508/05/27 (40)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *244A*

8/5/27

(40)

SL

Date: Wednesday, 21/05/2008 2:20:24 PM

User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39376

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28 *df*

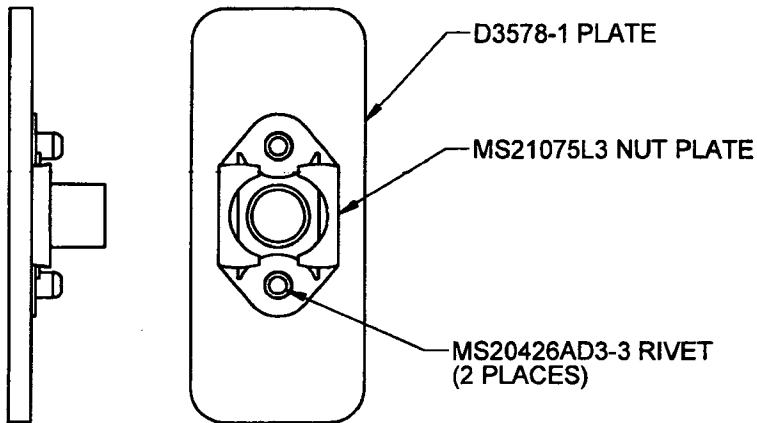
Job Completion



mf 08-05-27

DART

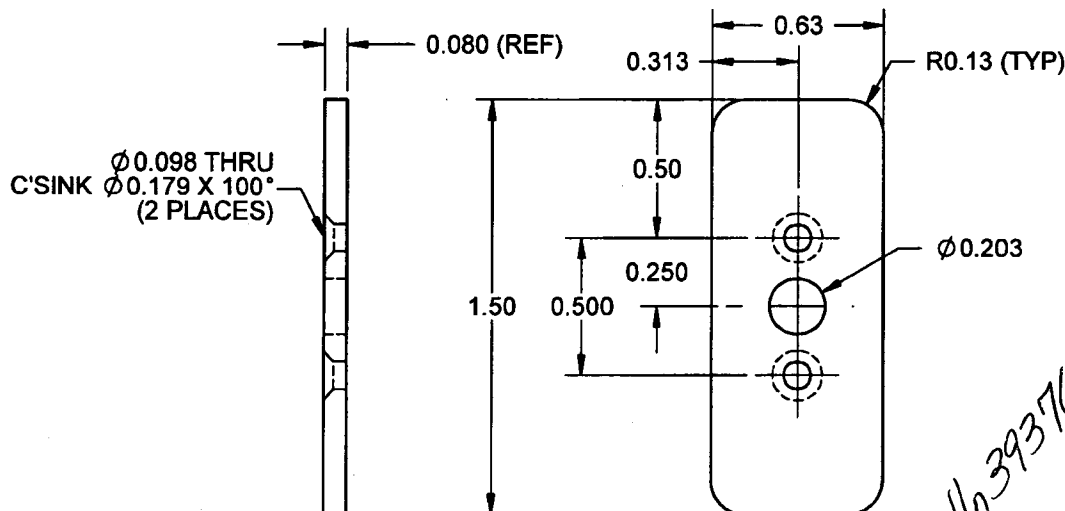
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER SCALE 3:2		
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**
07-04-02 *JB***D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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